

Work Order ID 79555

January-27-12 12:51:11 PM

79555

Page 1

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 27/01/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	B								
100		0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-weld D3806-5 to D3805-5 together as per dwg D3805 304 S.S. Welding Rod BATCH #: <u>M120013</u> <u>Sadel 2059B</u> → <u>M122279</u> 2-Transfer drill holes in bar								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

(X10)

MAL 12/07/24

10

12.7.24

DAS
24
20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 27/01/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 8.00 ***8*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating									

140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten notes and stamps:

- Stamp: DAS 16 8-83 12/14/24
- Stamp: (115)
- Signature: m.2
- Signature: WAD
- Date: 12/07/24
- Signature: M12127a
- Text: 3230
- Text: START TIME: 3200 F
- Text: OVEN TEMPERATURE: 3200 F
- Text: FINISH TIME: 4:00
- Text: 10 cp
- Text: 12/27/25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Packaging

10

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Ar
12.07.26

110

DAS
16
9-89

17/05/20

16y

50
12-7-27

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 79555

79555

Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3805-5		Manufactured	No			100	Each	65.0000	1	8			
D3805-5									**	(X10)		MAL	12/07/24
Plate													

B 79568 (X10)

Location	Loc Qty	Loc Code
WA030	65	
75676	2	
78128	60	
78811	3	

D3806-5		Manufactured	No			100	Each	14.0000	1	8			
D3806-5									**	(X10)		MAL	12/07/24
Bar													

B 79570 (X10)

Location	Loc Qty	Loc Code
WA	10	
74889	10	
WA030	4	
46781	2	
75941	2	

D3807-5		Manufactured	No			150	Each	64.0000	1	8			
D3807-5									**				
Gasket													

B 79626 → (7)
B 79572 → (3)

Location	Loc Qty	Loc Code
GA	64	
74944	1	
76742	1	
78132	62	

Ac 12.07.25

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B	REVISED 0808-11/09F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>g</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D3805 TITLE WEARPLATE ASSY	REV. 1	
DRAWN	<i>g</i>		SHEET 1 OF 1	
CHECKED	<i>g</i>		SCALE	
MFG. APPR.	<i>M</i>		NTS	
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DE APPR.	<i>g</i>			
DATE	11.09.16			

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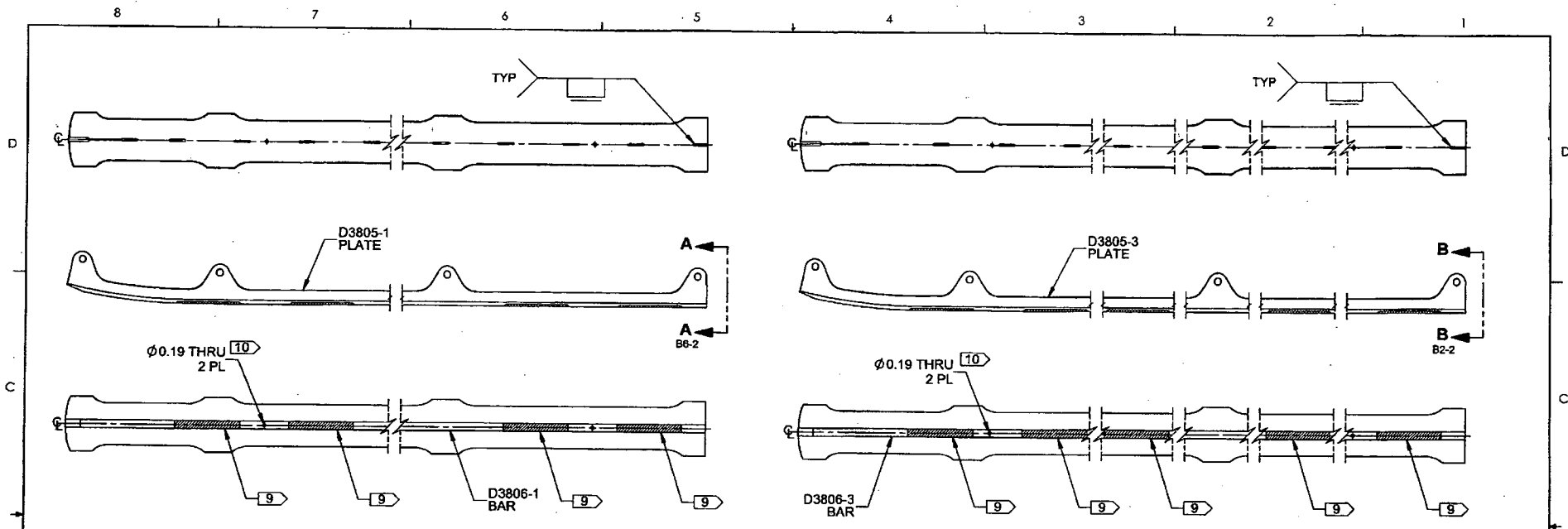
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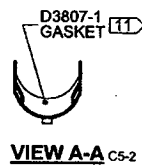
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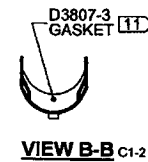


D3805-041 FWD WEARPLATE ASSY, LOW GEAR

D3805-043 FWD WEARPLATE ASSY, HIGH GEAR







VIEW A-A C5-2



VIEW B-B C1-2

RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2053B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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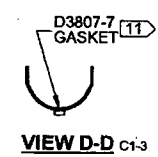
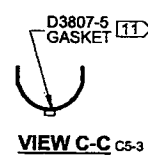
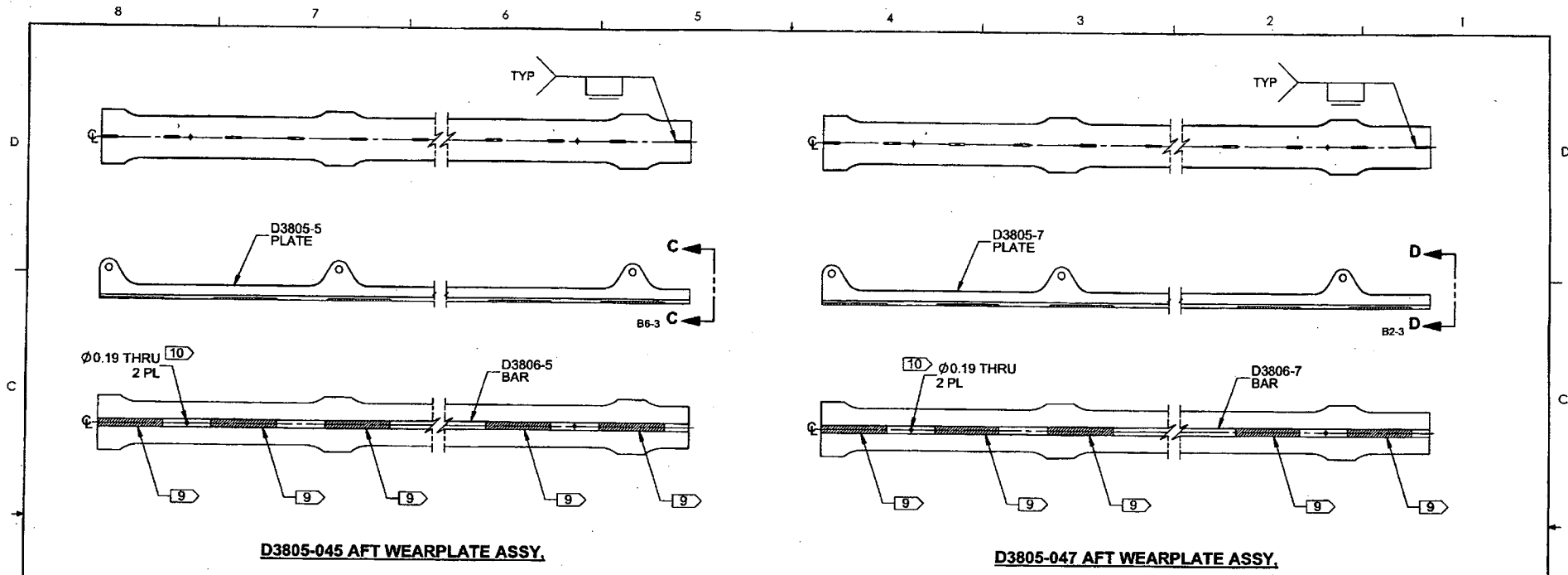
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RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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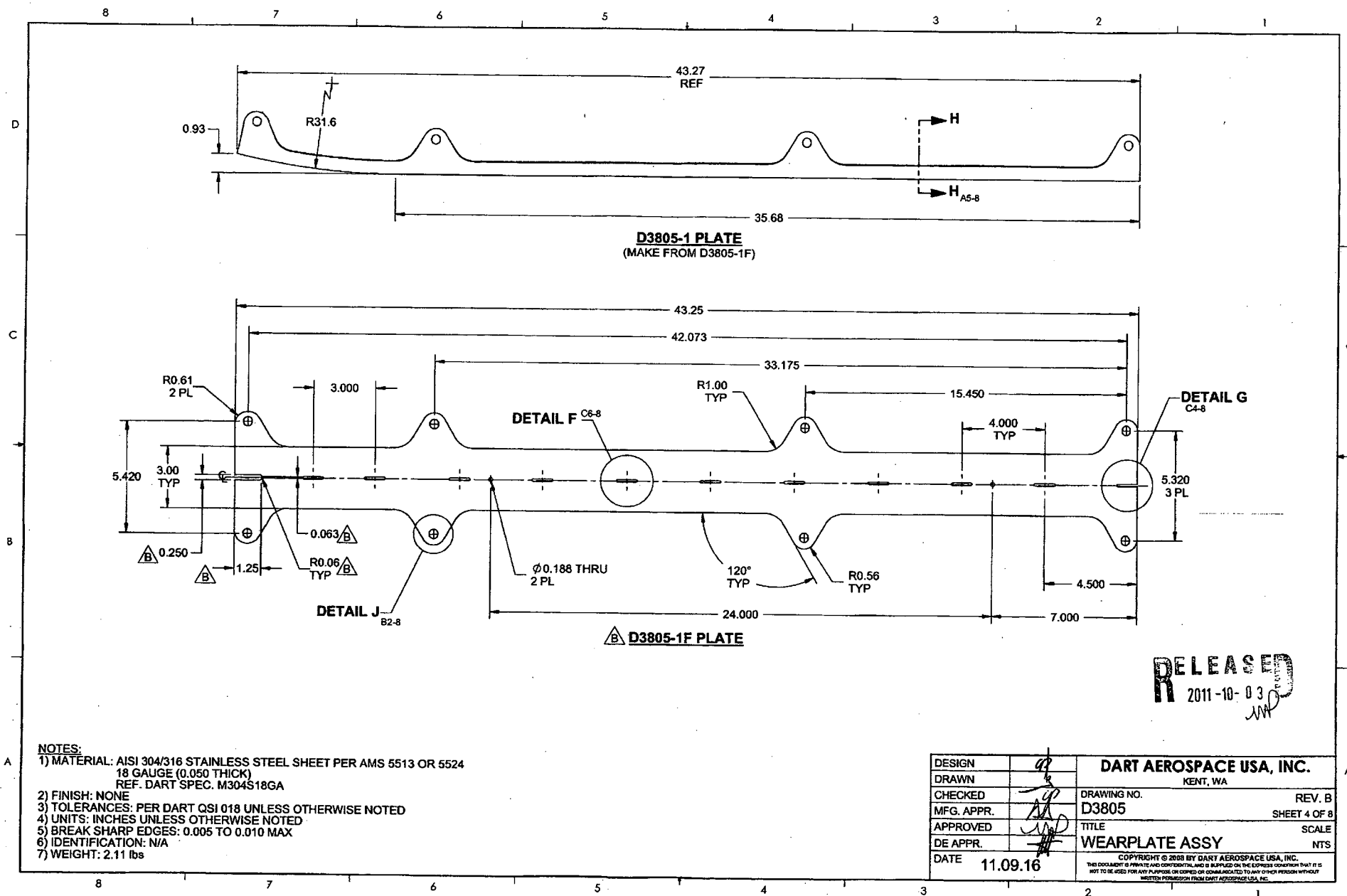
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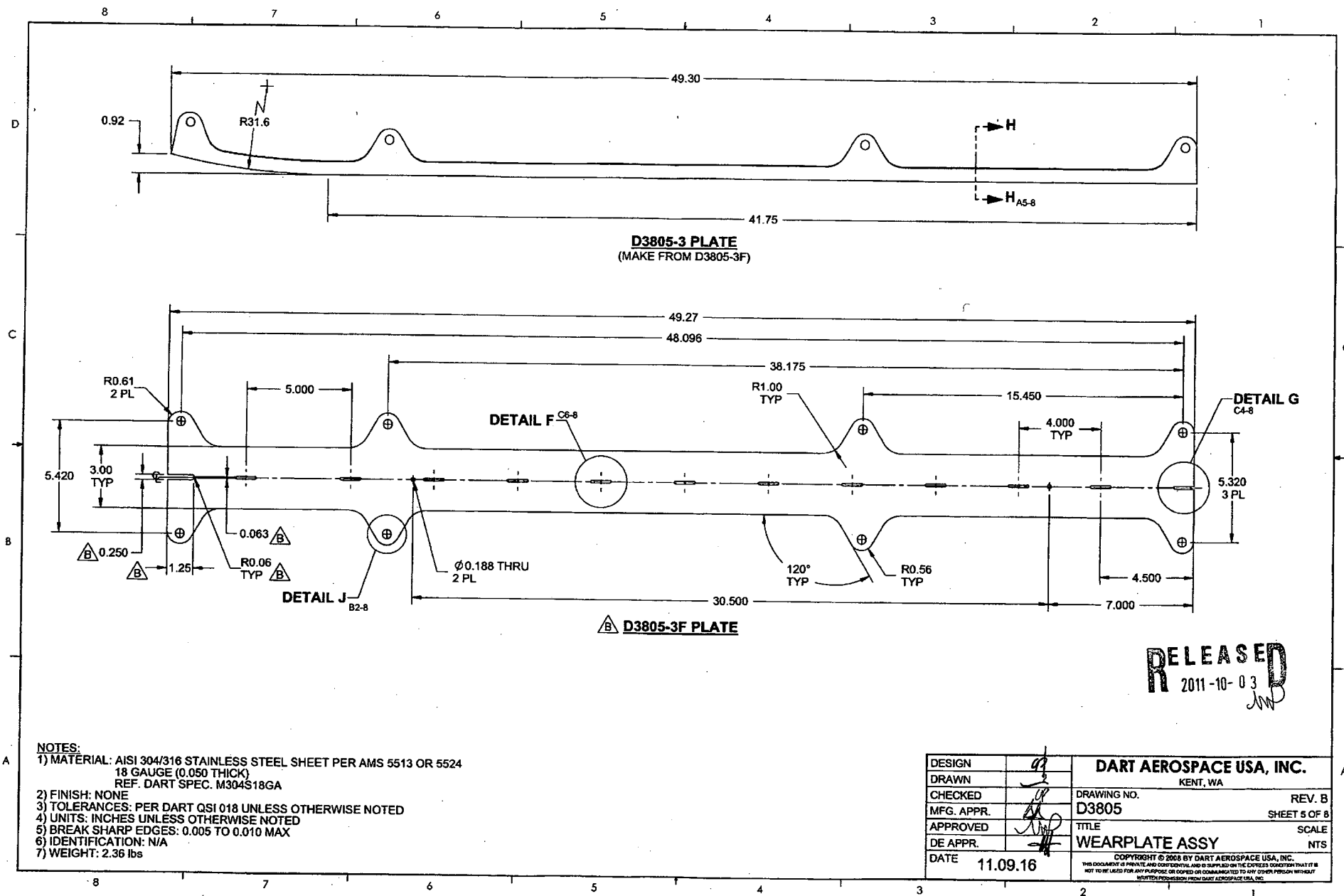
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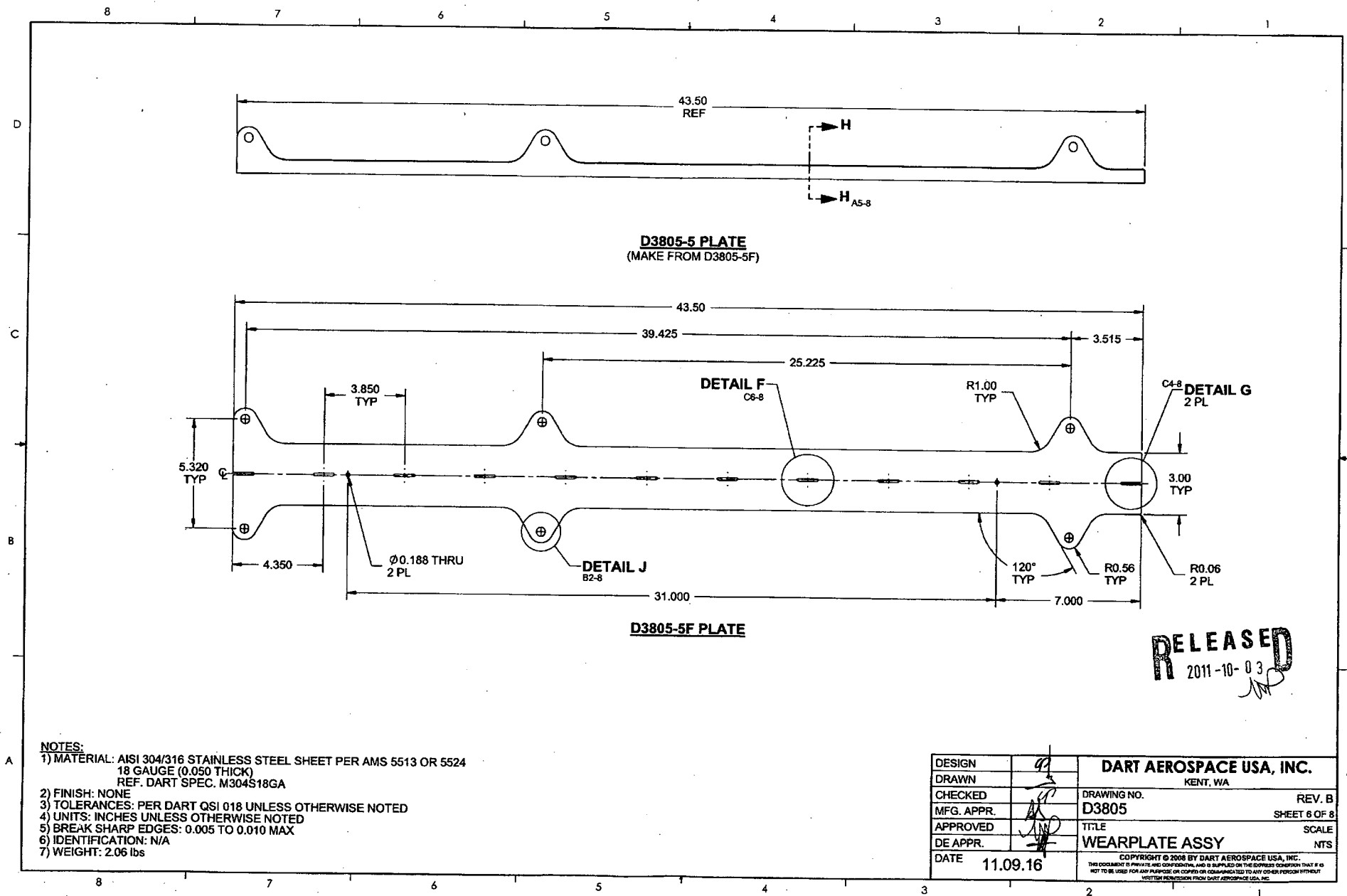
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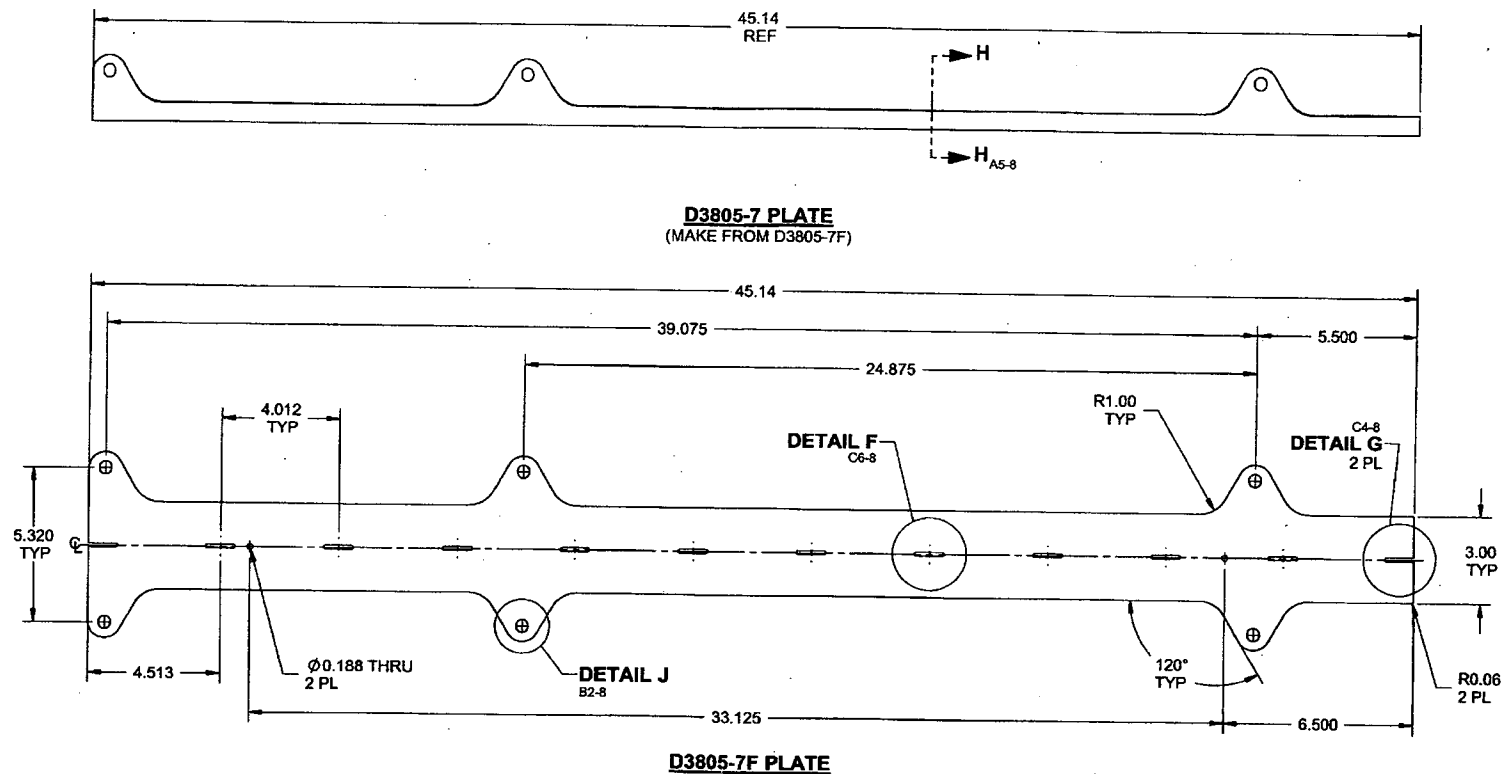
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2011-10-03
ND

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE USA, INC.
DRAWN		KENT, WA
CHECKED		DRAWING NO. D3805
MFG. APPR.		REV. B
APPROVED		SHEET 7 OF 8
DE APPR.		TITLE WEARPLATE ASSY
DATE	11.09.16	SCALE NTS
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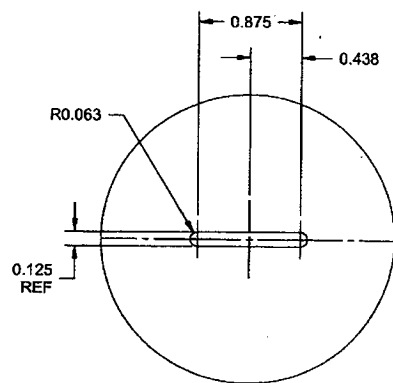
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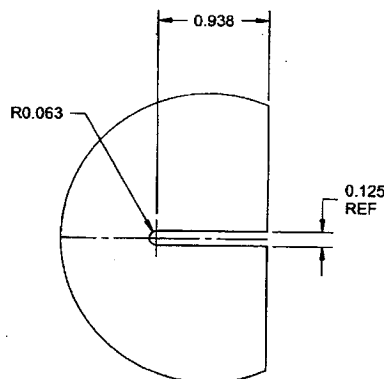
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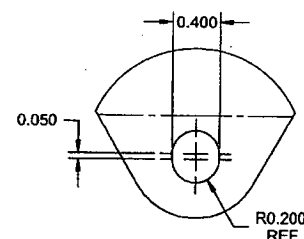
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



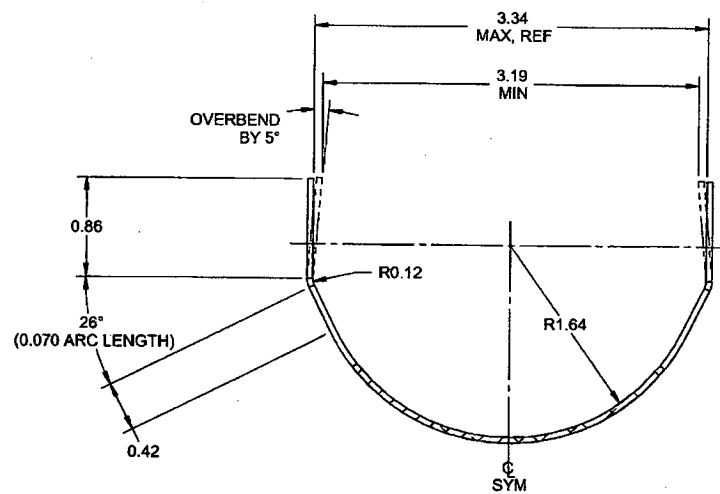
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

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